

Date: Thursday, 3/2/2006 3:07:29 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 26027		
Estimate Number	: 10195		
P.O. Number	: N/A	Part Number	: D21741
This Issue	: 3/2/2006 S.O. No. : N/A	Drawing Number	: D2174-1 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: N/A	Material	: N/A
Written By	: <u>SRE COMMENT BELOW</u>	Due Date	: 3/25/2006 Qty: 40 Um: Each
Checked & Approved By	: <u>06.03.02</u>		
Comment	: Est C 04.06.09 Reformat KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: M19059

mk 06/03/18

40

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 12.75" x 4.83" Grain along 12.75"

mk 06/03/18

40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA097 and Dwg D2174

Stack of 10

Identify as D2174-1

mk 06/03/18

40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 06/03/18

40

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 06/03/18

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

ml *[Signature]* 06/03/22 40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Signature] 06-03-23 40

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06:04:02

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

[Signature] 06-04-05 40

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 220

[Signature] 06/4/5 (40)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

[Signature] 06/04/05 (40)
u 06/04/05

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26027
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.249	—			
6.400	+/-0.010	6.401	—			
4.800	+/-0.010	4.797	—			
1.375	+/-0.010	1.376	✓			
1.050	+/-0.005	1.050	✓			
Ø0.128	+0.005/-0.000	Ø0.132	✓			
12.650	+/-0.010	12.650	—			
0.550	+/-0.010	0.555	—			
0.900	+/-0.010	0.900	—			
1.629	+/-0.010	1.625	—			
1.506	+/-0.005	1.505	—			
11.550	+/-0.005	11.550	✓			
50°	+/-0.5°	50°	—			
0.063 thick	+/-0.010	0.064	—			

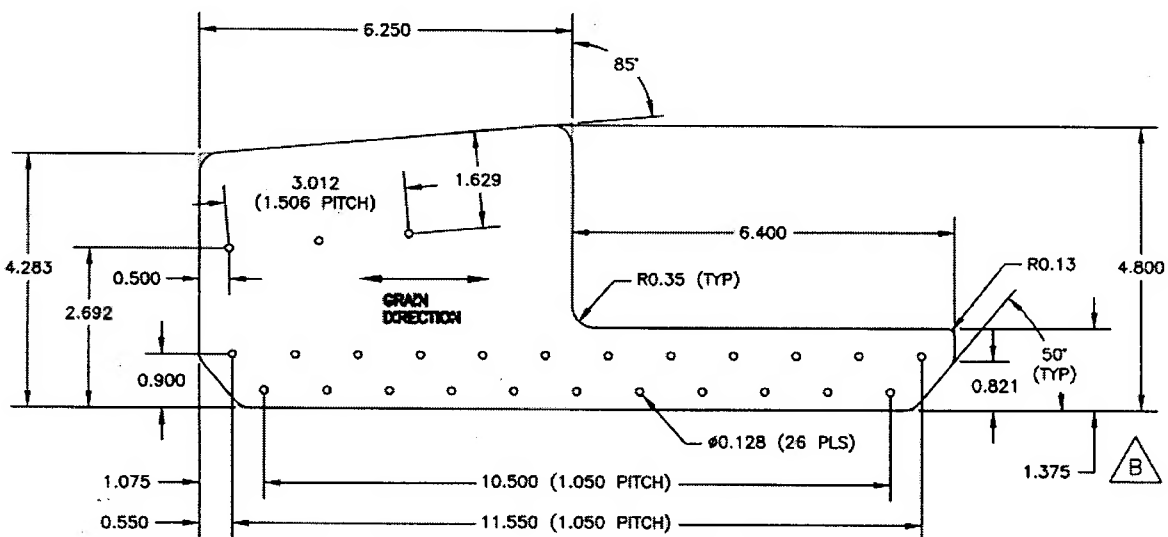
Measured by:	JL	Audited by:	JL	Prototype Approval:	N/A
Date:	06/03/18	Date:	06.03.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	



DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 0	
		D2174-1	SHEET 1 OF 1	
DATE	TITLE		SCALE	
04.06.03	WEB		1:3	
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN CHANGE DIMENSION		
C	00.09.11	UPDATE FINISH SPEC		
D	04.06.03	RE-DESIGN		

RELEASED
04.06.07



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES



NO. 26037

